

00053

Date: Wednesday, 8/30/2006 11:56:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28356
 Estimate Number : 12491
 P.O. Number :
 This Issue : 8/30/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev. New Issue 06-07-26 JLM

Drawing Name : GPS RECEIVER HOUSING
 Part Number : D35141
 Drawing Number : UNDER REVIEW CB 06.08.30
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 9/6/2006 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.4812 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M100742

MA 06 08 30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: Prel

Prog Rev: Prel

Ensure Grain Direction is correct**

2-Deburr if necessary

MA 06 09 07

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MA 06 09 07

①

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06.07.07

①

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink as per Dwg D3514

SA 06/09/07

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.09.03	2.0	Scrap 1 piece because holes were not in tolerance with the drawing						

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28356

Part Number: D35141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE

06.09.14

①

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB

06.09.14

②

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE

06.09.14

①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

06-09-14

④

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RE

06.09.14

①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Per eng. use only.

RE

06.09.14

①

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

207103108

Job Completion



u 06-09-14

Eng Approval

CB 07.07.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

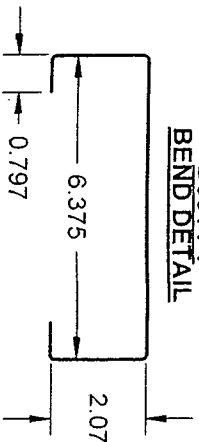
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD
CB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3514
DATE	TITLE	REV. A
06.05.03	GPS RECEIVER HOUSING	SHEET 3 OF 7
		SCALE 1:4

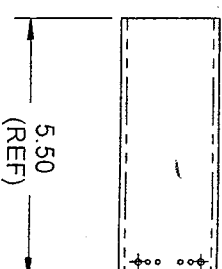
D3514-1 BEND DETAIL



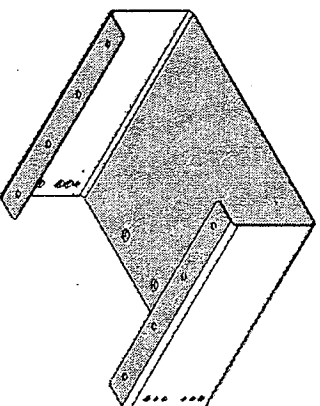
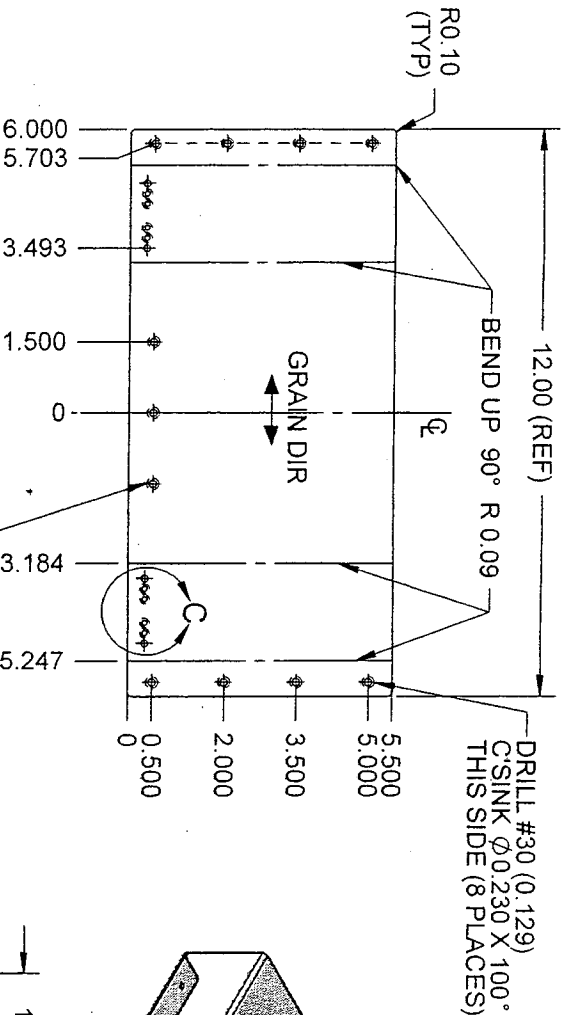
UNDER REVIEW

06.02.22 CB

154040111c



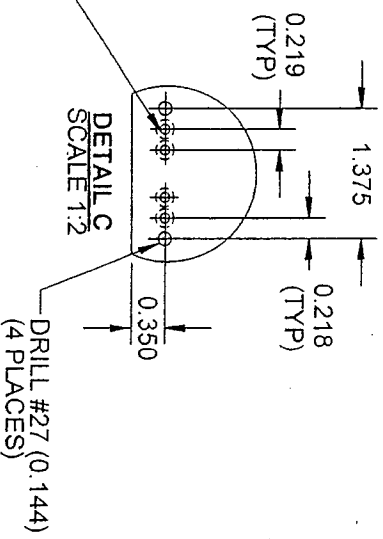
11, 813



D3514-1F FLAT PATTERN

DRILL #30 (0.129)
C/SINK Ø0.230 X 100°
THIS SIDE (3 PLACES)

DRILL #40 (0.098)
C/SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET (REF. DART SPEC. (M6061T6S 040))
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT Q
- 7) C/SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28350

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WORK ORDER **		04/13/06 ORD		1551 RESUBS	
SHIP TO		DELIVERY DATE	SHIP BRANCH	SELL BRANCH	WORK ORDER
04/24/06 DEL		30(04)	30-TOR	UZ3809	
SPACE ERDEEN ST SBURY ON CANADA K6A 1K7		6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y			
01		Copper and Brass Sales Canada			
000001005		TERRITORY 01		ENTRY ID 30BXT	
INDA LACELLE		INSIDE SALES		BRIAN TEDESCO	
513) 632-9577		INSIDE SALES TELEPHONE		(905) 696-8100 37622	
SHIP VIA		SHIPPING STATUS		CUSTOMER SIGNATURE	
COMPLETE X		PARTIAL		DATE	
COMMON/FRT-CCX		DEST		PACKED WITH OTHER GOODS UZ3800	
PPD		FINISHED GOODS LOCATION		WARN LABEL:1001	

PART DESCRIPTION: 063496-4
 061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 DART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 Dimensions., Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

SPECIAL INSTRUCTIONS:
 Shipping, do not place any packages or goods on top of our material."

SCRAP		FILLED BY SC		PACKED BY		Q/A AUDIT	
MAX SKID WEIGHT 100		LOADING INSTRUCTIONS		HAND, CRANE, FORK, DOCK		MAXIMUM BUNDLE WEIGHT 200	
PKGS	SKIDS	BOLS	TUBES	CTNS	FLAT	COILS	
INSPECTION	RECORD						

TEST RESULTS -----
 CERTIFICATE OF COMPLIANCE
 I hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 I certify that the products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 1-800-244-233-5682. We hereby certify that the material above complies with the following specifications:
 AMS 4027 ASTM-B209
 ROHS COMPLIANT

QUANTITY	UOM	VENDOR	VEND PO	HEAT/LOT	PCS	TAG NO	QUANTITY	UOM	VENDOR	VEND PO	HEAT/LOT	PCS
52.00	LB	CORUS	OCC1837	7124901								

M100792